

Work Order ID 59844

Monday, June 14, 2010 12:46:08 PM



Page 1

Item ID: D3825-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket End)

Stop



Start Date: 6/14/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 6.00



Customer: *

Reference:

Approvals: Process Plan:

Date: 10-06-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3825

Rev A

100



Large Fab

Large Fab

Memo

0.00

0.00

Large Fab

1- cut D3825-1 rib as per dwg D3825

2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825

A/R S.S. Rod Batch: 111079

SAD 10-06-14

7- grind bushing weld flush where indicated on dwg D3825

8- deburr if necessary

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59844

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Item ID: D3825-041

Accept



Setup Start

**Revision ID:****Item Name:** Rib Assembly (Basket End)

Stop

**Start Date:** 6/14/2010 **Start Qty:** 6.00**Cust Item ID:****Required Date:** 6/18/2010 **Req'd Qty:** 6.00**Customer:****Reference:****Approvals:****Process Plan:****Date:****Tooling:****Date:**

Run Start

**QC:****Date:****SPC (Y/N):****Date:**

Stop

**Sequence ID/
Work Center ID**

130



QC

Quality Control

**Operation
Description**

QC9- Inspect visual per QSI004- Fusion Welds

**Set Up/
Run Hours**

0.00

Tool ID**Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

(6) AD 10.06.24

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/24

(76)

150



Packaging

Packaging

Identify as per dwg & Stock Location: B/C

0.00

Memo

0.00

PPL 10-06-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 14, 2010 12:46:13 PM

Page 1

Work Order ID: 59844



Parent Item: D3825-041



Parent Item Name: Rib Assembly (Basket End)

Start Date: 6/14/2010

Required Date: 6/18/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3		Manufactured	No		100	Each	2.0000	1	6			<i>PCL 10-06-24</i>
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Spacer Bushing				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA		2						
					58406	2						

D3759-1		Manufactured	No		100	Each	16.0000	1	6			<i>PCL 10-06-24</i>
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Bushing				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
				WA		16					
					54072	9					
					58672	7					

M304TS0.750W.065		Purchased	No		100	f	938.4760	2.125	13.42105			<i>SAD 10-06-24</i>
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304 SQ Tube .75x.75x.065W				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT		53.32232					
					112398	0					
					114482	53.32232					

				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
				WA		885.1537				
					114520	885.1537				

22368

1118425

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

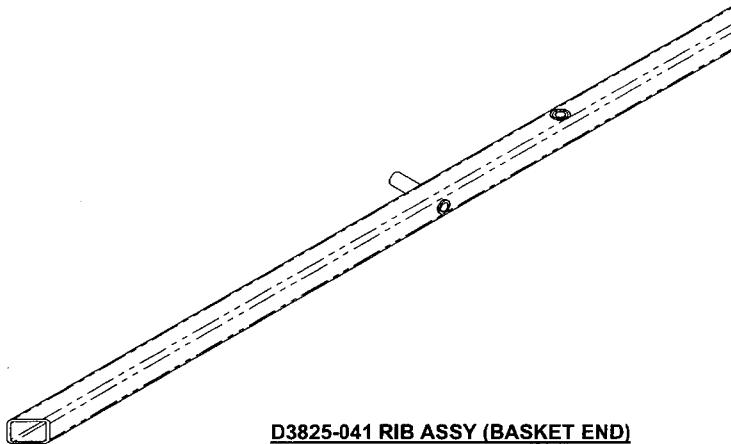
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB

D3825-041 RIB ASSY (BASKET END)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59844

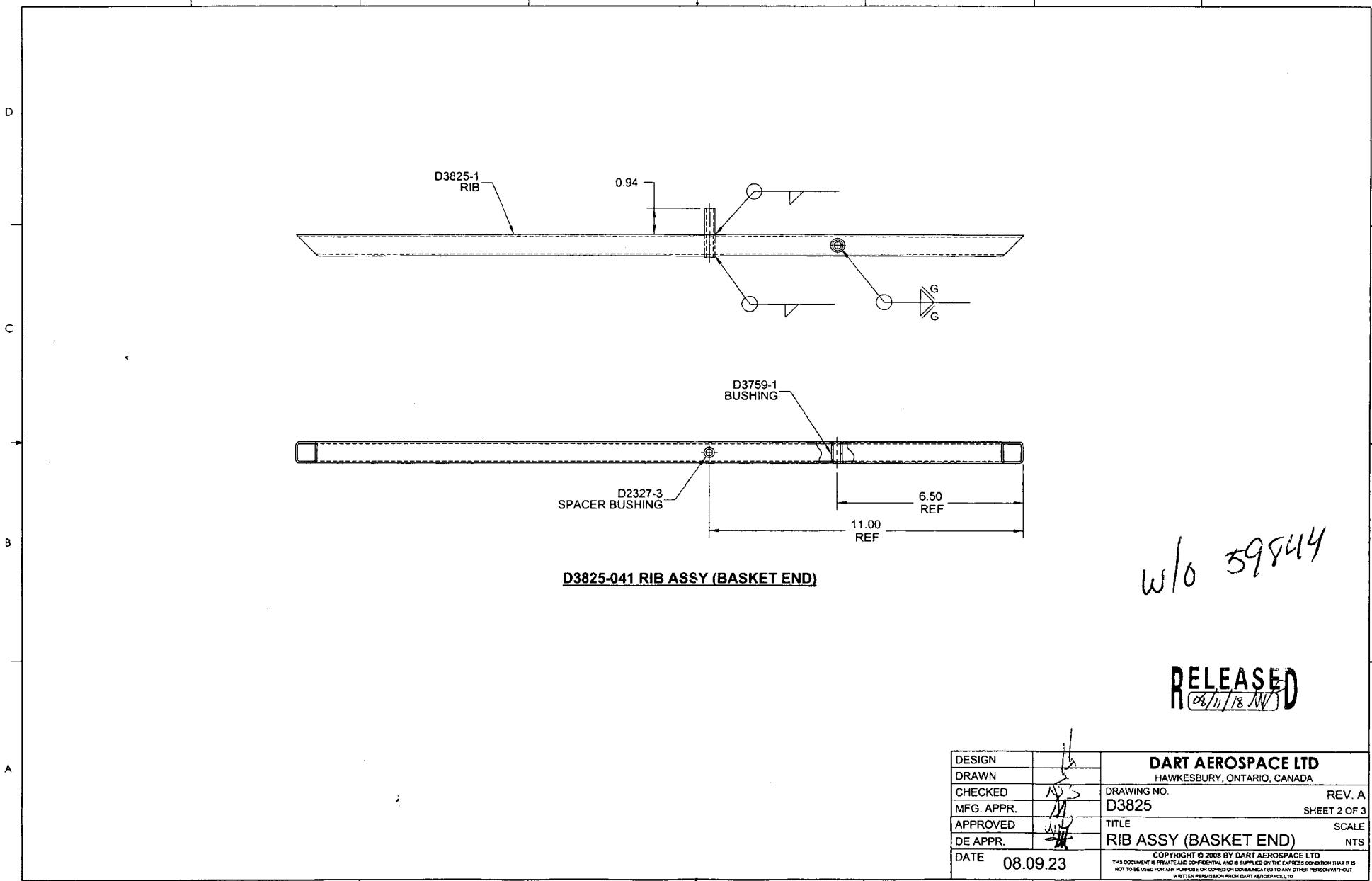
BD 10-6-14**RELEASED**
08/11/18

- A NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.22 lbs
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>1</u>	DART AEROSPACE LTD	
DRAWN	<u>2</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>3</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>4</u>	D3825	SHEET 1 OF 3
APPROVED	<u>5</u>	TITLE	SCALE
DE APPR.	<u>6</u>	RIB ASSY (BASKET END)	NTS
DATE	08.09.23	COPRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3825	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY (BASKET END)	NTS
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8 7 6 5 4 3 2 1

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D

D

C

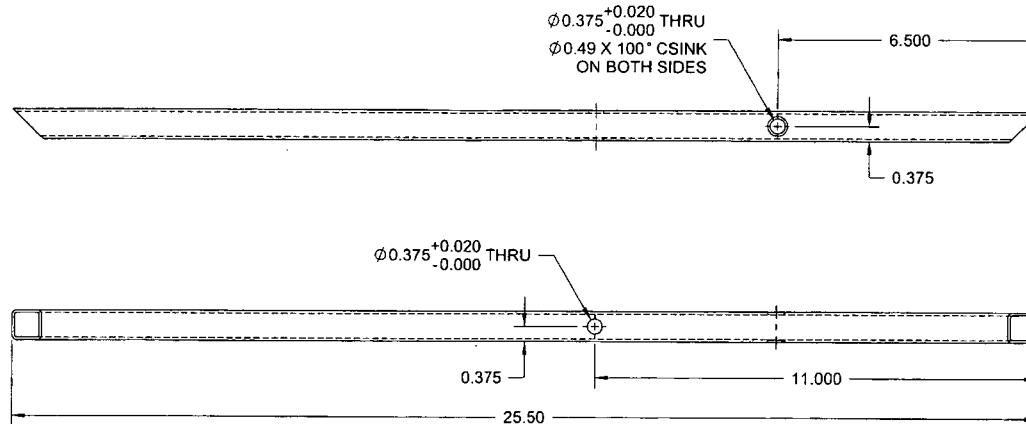
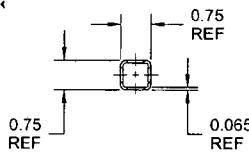
C

B

B

A

A

D3825-1 RIB

WLO 58844

RELEASED
(08/11/18 MAF)

- NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.18 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PS</i>	DRAWING NO.
MFG. APPR.	<i>MA</i>	REV. A
APPROVED	<i>SJH</i>	D3825 SHEET 3 OF 3
DE APPR.	<i>CH</i>	TITLE
DATE	08.09.23	SCALE
		NTS
RIB ASSY (BASKET END)		
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8 7 6 5 4 3 2 1